

Work Order ID 163277

Tuesday, June 27, 2017 12:01:12 PM

163277

Page 1

Item ID: D2161-212 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID:
 Item Name: Mirror Bracket, 212 Stop ***NS2***
 Start Date: 7/7/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/14/2017 Req'd Qty: 2.00 ***2*** Customer:

Reference: **DAS**
 Approvals: Process Plan: **21** Date: **JUL 03 2017** Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2161	Rev B2

100	Weld per dwg A/R S.S. rod Batch: M136585	0.00							
100	Large Fab								
Large Fab	Memo	1.62							
Large Fab	1-Assemble on Jig DT8065 as per Dwg D2161 2-Weld as per Dwg D2161 Identify as D2161-212								

② DYC
17/07/12

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

② 17.07.13 DAS
9
9-89

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.04							
Quality Control									

② 17.07.13 DAS
9
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

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Page 2

Item ID: D2161-212 Accept ***N900040100*** Setup Start ***NS1***
Revision ID:
Item Name: Mirror Bracket, 212 Stop ***NS2***
Start Date: 7/7/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/14/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M13630</i> Memo START TIME: <i>1:40</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:10</i>	0.00 0.20				<i>2</i>	<i>0</i>	<i>17-07-27</i>	<i>8 5 8</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02				<i>2</i>			<i>DAS</i> <i>38</i> <i>JUL 28 2017</i>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <i>S1229A</i> Memo	0.00 0.02				<i>2</i>		<i>AUG 01 2017</i>	<i>DAS</i> <i>6</i> <i>9-88</i>

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Item ID: D2161-212 - - - - - Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 7/7/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/14/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.20							
Quality Control									



AUG 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 163277

163277

Parent Item: D2161-212

D2161-212

Parent Item Name: Mirror Bracket, 212

Start Date: 7/7/2017

Required Date: 7/14/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D02.04.15Added dwg Rev.B1 and finishNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2013-3		Manufactured	No			100	Each	4.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2013-3

OK Mirror Bracket LH, 212

**

DYC 17/07/12

Location

Loc Qty

Loc Code

WA001

4

159998

4

D2013-4		Manufactured	No			100	Each	5.0000	1	2			
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D2013-4

OK Mirror Bracket RH, 212

**

DYC 17/07/12

Location

Loc Qty

Loc Code

WA001

5

158212

1

160001

4

D2037-101		Manufactured	No			100	Each	3.0000	1	2			
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D2037-101

OK Arm

**

DYC 17/07/12

Location

Loc Qty

Loc Code

WA001

3

145478

1

158214

1

160006

1

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

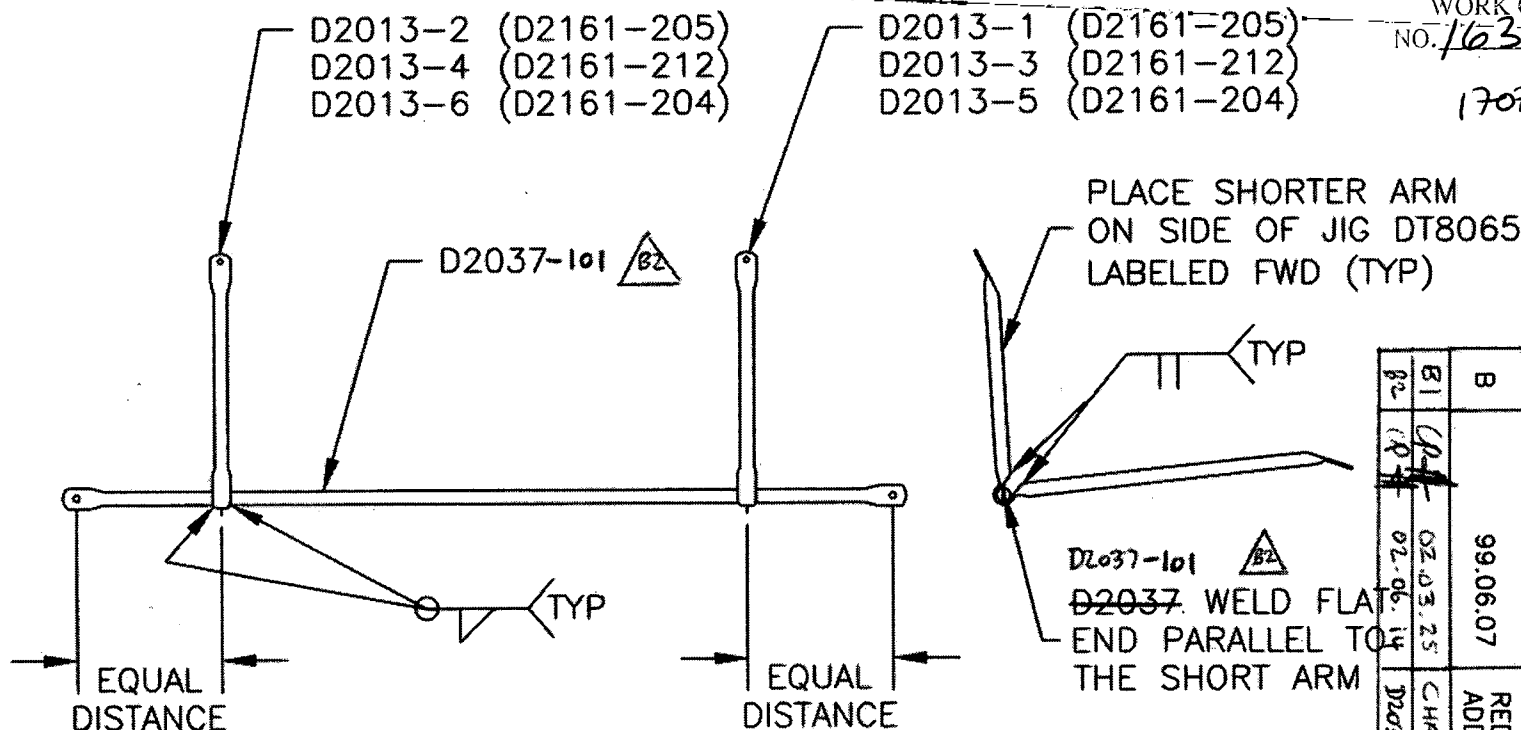
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 163277
1707-03
MLW

DART



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D2037-101 (B2)
WELD FLAT
END PARALLEL TO
THE SHORT ARM

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~
~~DART QSI 005 4.3~~ (B1)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURG, ONTARIO, CANADA	REV. B
JB	RT		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	RT	D2161	
DATE	TITLE	SCALE	
99.06.07	MIRROR BRACKET	NIS	
A	93.04.29	NEW ISSUE	
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
B1	02.03.25	CHANGE FINISH	
B2	02.06.14	D2037-101 W	

RELEASED
KE 99.06.10